





Date: Monday, 1/22/2007 7:45:36 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 30343		
Estimate Number	: 10176		
P.O. Number	: <i>N/A</i>	Part Number	: D2563
This Issue	: 1/22/2007	Drawing Number	: D2563 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: C
Previous Run	: 29537	Material	: <i>N/A</i>
Written By	: 	Due Date	: 2/9/2007
Checked & Approved By	:  02.01.22	Qty:	10
Comment	: Est Rev: 02.07.31 Re-format Location RF	Um:	Each

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2244116 	Step Extrusion 

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:
1 D2244 Step Extrusion
Batch: 328216-6 323404-4

2.0	D267334	End Plate
-----	---------	-----------

Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
Pick:
Qty Part No. Description Batch
2 D2673-34 End Cap B25396

3.0 D2561 Lug Plate

Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 20.0000 Each(s)	
Pick:			
Qty	Part No.	Description	Batch
2	D2561	Lug Plate	B-28800 #2 B-24461 = 8 + 1 scrap

P.E. 07-01-30

4.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part No.</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2564</td> <td>Mounting Angle</td> <td>327418</td> </tr> </tbody> </table>					Qty	Part No.	Description	Batch	2	D2564	Mounting Angle	327418
Qty	Part No.	Description	Batch									
2	D2564	Mounting Angle	327418									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:45:36 AM
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Drawing Name: STEP WELDMENT

Job Number: 30343

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Debur ends

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M100237

M102025

4-Grind

PE 07-01-30

PE 07-01-31

PE 07-02-31

PE 07-02-1

10

10

10

10

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07-02-01 (10) / PD 07-02-01 (10)

(10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. D. / PE

07/02/02

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u 07-02-02

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M100237

3-Grind

PE 07-02-06

PE 07-02-06 (4) FF 07-02-06

10

10

6

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/02/06 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:45:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 30343

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Johnston

10

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/a.m

a.m.

07/02/06

10

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

m 103004

a.m 07/02/06

10

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 7/02/06

(10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/06

10

Job Completion



U 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

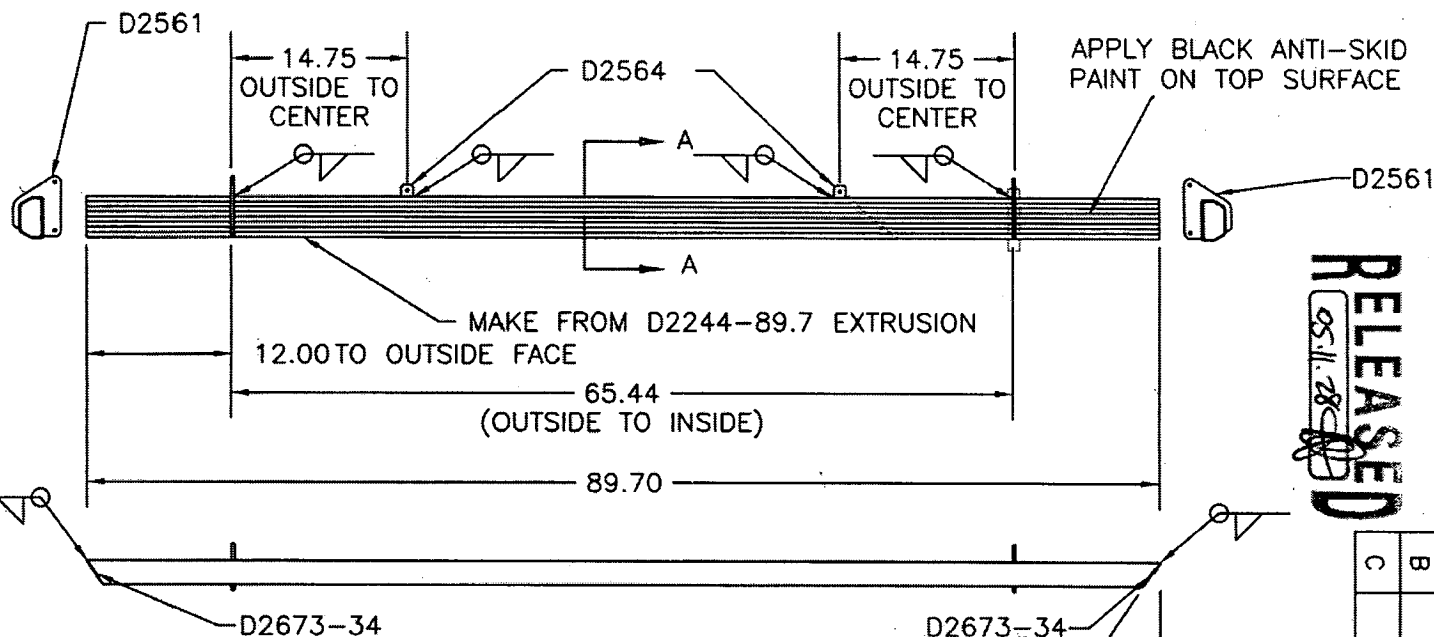
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO ATTENDING
WITHOUT NOTICE
WORK ORDER
30343

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED	DRAWING NO. D2563
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE	REV. C
B	97.05.14	END CAPS CHANGED (WAS D2248)	SHEET 1 OF 1
C	05.11.14	UPDATE NOTES	SCALE 1:15